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26

DART AEROSPACE LTD.	Work Order :	18542
Description: 206B Float Step Assy, LH	Part Number:	-D2841-041-
Drawing: D2841 Rev. A	Qty:	2

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	JA	02.12.10	2
2	METAL	Cut D2841-1 using D2622 extrusion as per Dwg D2841 Batch No. <u>B14068</u>	DA	03/01/10	2
3	METAL	Drill extrusion per drawing D2841 using Jig DT 8265	DA	03/01/10	2
4	METAL	Deburr and bevel ends for welding	DA	03/01/10	2
5	STORES	Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>B15037</u> 1 D2843-1 Lug <u>B18582</u> 1 D2843-3 Lug <u>B18583</u>	DA	03/01/10	2
6	QC	Inspect for foreign object per QSI 024	DA	03/01/15	2
7	WELDING	Weld end caps and lugs as per Dwg D2841 using Jig DT 8267 followed by DT 8268	DA	03/01/15	2
8	METAL	Grind end cap welds flush	DA	03/01/15	2
9	QC	Inspect Level 9	DA	03/01/16	2
10	QC	Inspect Level 5	DA	03/01/16	2
11	FINISHING	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3.	DA	03/01/16	2
12	QC	Inspect Level 3	DA	03/01/17	2
13	STORES	Pick: Qty Part Number Description Batch 2 ALS7-1032-130 Insert <u>m9073</u>	DA	03/01/20	2
14	METAL	Install inserts as per Dwg 2841	DA	03/01/20	2
15	METAL	Wing Walk per Dwg 2841 and QSI 005 4.4 Ensure this W/O is with RH Steps	DA	03/01/20	2
16	QC	Inspect Level 5	DA	03/01/20	2
17	STORES	Identify and stock	DA	03/01/20	2
18	EXPEDITING	Close W/O Cost / Part <u>102.81</u> <u>SAC 03/01/23</u> (2)	DA	03.01.23	-

Rev	Date	Change	Revised By	Approved
A	98.11.20	New Issue	DM	
B	99.12.08	Added step 11, 12	EC	
C	00.07.20	Added inspection for QSI 024	EC	
D	00.11.01	Removed P/O for Powder Coat - in house process	EC	

RELEASED

DEC 18 2000

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

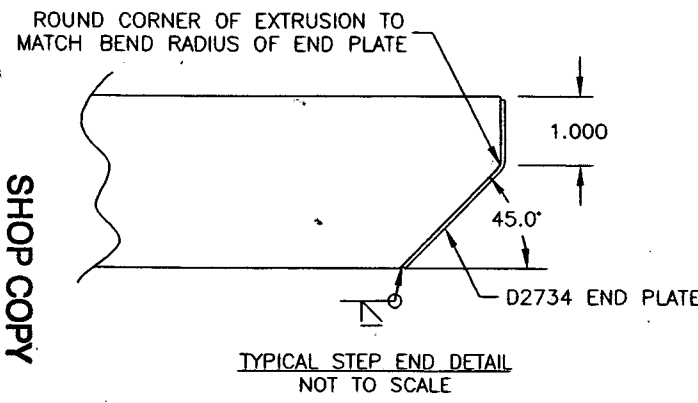
QA: N/C Closed: _____ Date: _____

DART

ISSUED

RELEASED
98.11.11 KE

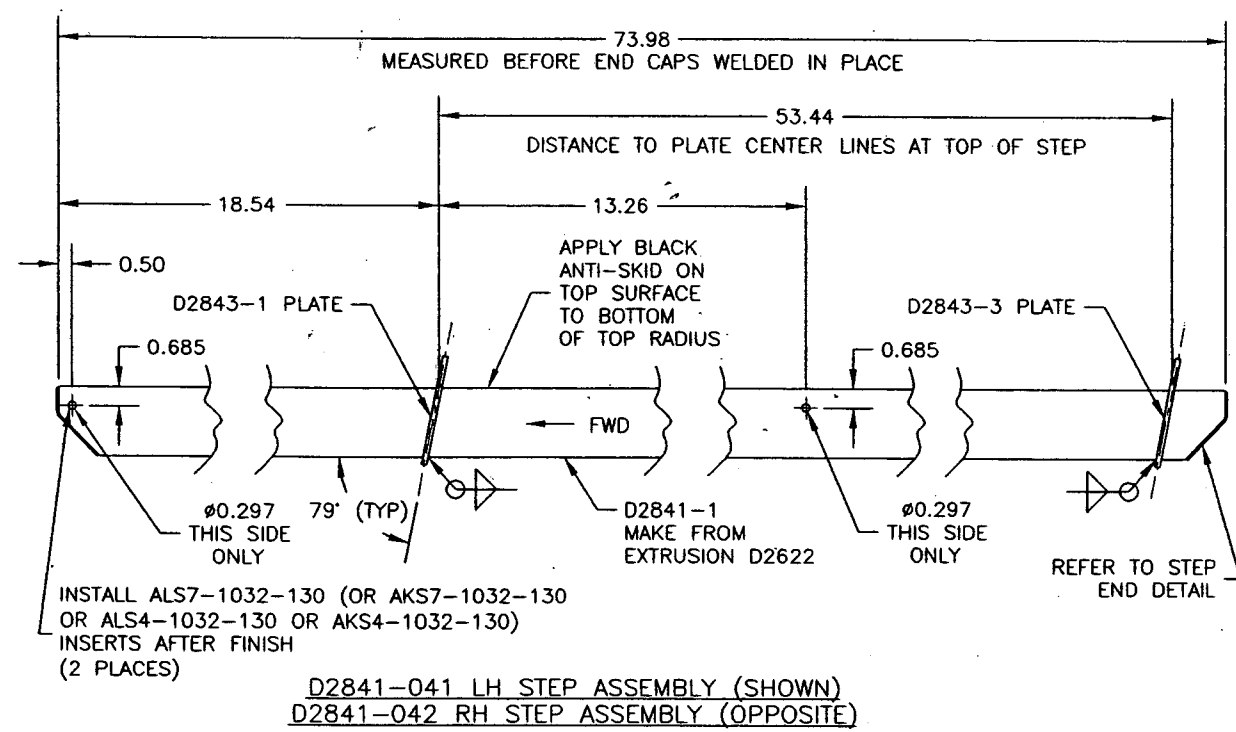
DESIGN	KE	DRAWN BY	KE	DART AEROSPACE USA, INC.
CHECKED	KE	APPROVED	KE	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	98.10.14	TITLE	D2841	REV. A
			206B FLOAT STEP ASSEMBLY	SHEET 1 OF 1
			NEW ISSUE	SCALE
				1:1



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 18542



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 10, 2002
11:26 am

Work Order No : 0018542
Project Name : D2841-041
Project For : week 304
Work Order Type : Main
Main WO Number :
House Part Number : D2841-041
Description : Step Ass'y
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date :
Est Finish Date : 01-23-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00